

Work Order ID 145051

May 02, 2016 2:14:32 PM

145051

Rush for an order Page 1

Item ID: D3805-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 5/3/2016 Start Qty: 30.00

27

16 8H
16

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 30.00

37

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 20160502

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

D

100

0.10

100

Waterjet

Memo

6.00

FLOW CNC Waterjet

1-Cut as per Dwg D3805

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

19

Re 16/05/05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.30

Quality Control

19

Re 16/05/05

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition																			
				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
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OTHER : ☐																					

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

30

Cust Item ID:

Start Date: 5/3/2016 **Start Qty:** 30.00

Required Date: 5/10/2016 **Req'd Qty:** 30.00

30

Customer:

Reference:

Run	Start	*NR1*
	Stop	*NR2*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.60

Quality Control

DAS
38
~~9-99~~

MAY 06 2016

130

0.12

130

Brake NC

Memo

0.90

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

**DAS
30
9-89**

MAY 06 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.60

Quality Control

DAS
38
9-89

MAY 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Work Order ID 145051

May 02, 2016 2:14:34 PM

145051

Page 3

Item ID: D3805-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 5/3/2016 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 5/10/2016 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>in A 81</u>	0.00							
150									
Packaging	Memo	0.30							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	3.00							
Quality Control									

MCS MAY 13 2016
~~MCS MAY 11 2016~~
MCS MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 145051

145051

Parent Item: D3805-1

D3805-1

Parent Item Name: Plate

Start Date: 5/3/2016

Required Date: 5/10/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	385.3732	1.862	58.8			

M304S18GA

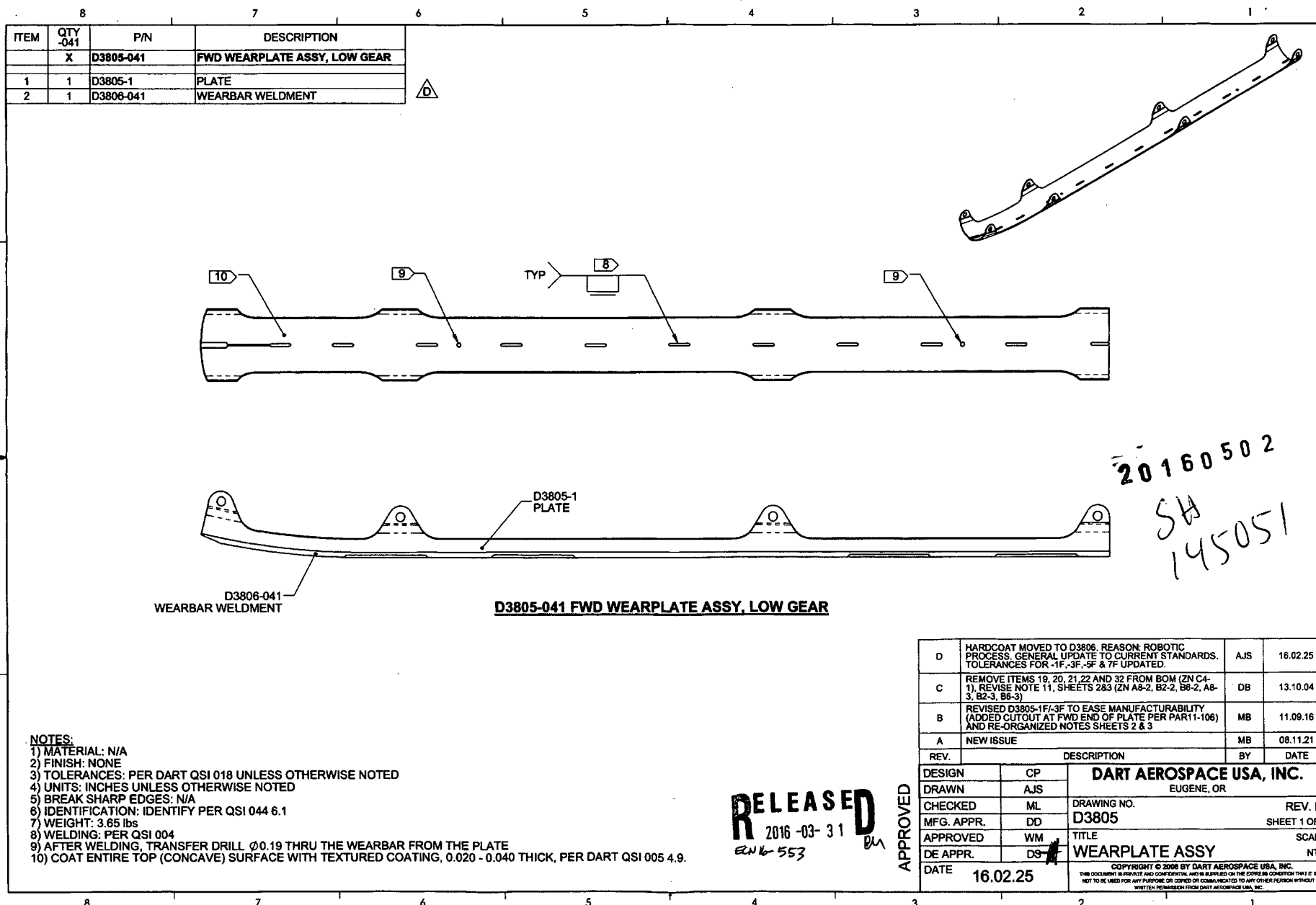
304/316 .050 Sheet

re 16/05/10

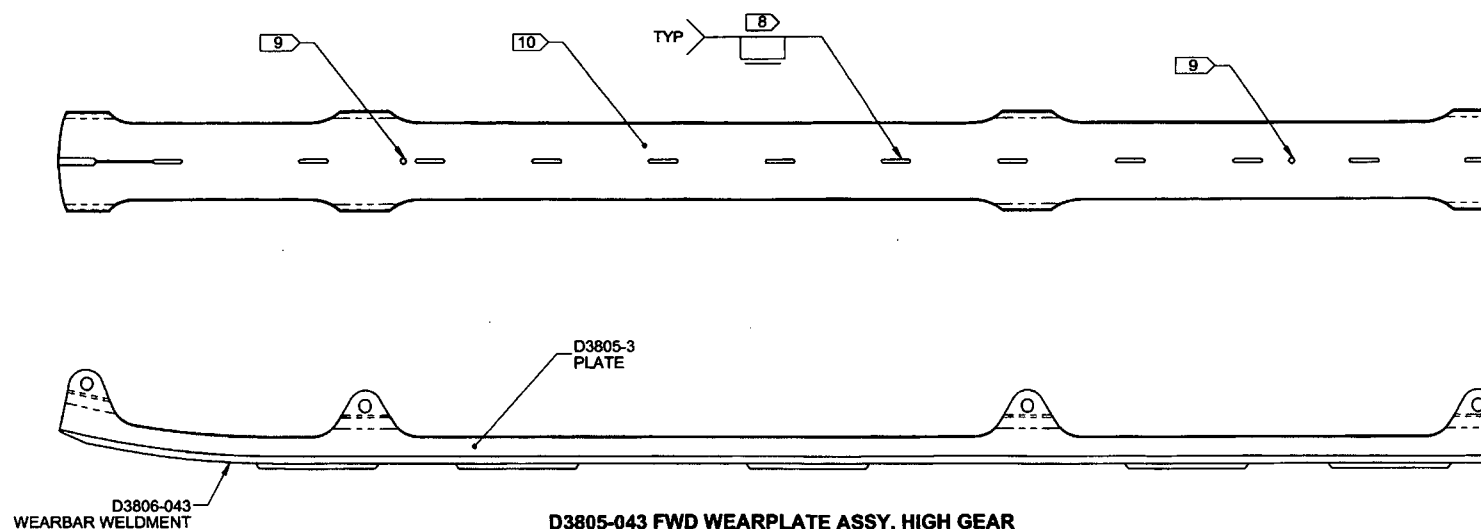
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M133328	110.796	
M133587	53.225	
MAT20	128	
M134580	128	
TPI	93.3522	
M134604	93.3522	

128435

25



ITEM	QTY	P/N	DESCRIPTION
	-043		
	X	D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
1	1	D3805-3	PLATE
2	1	D3806-043	WEARBAR WELDMENT



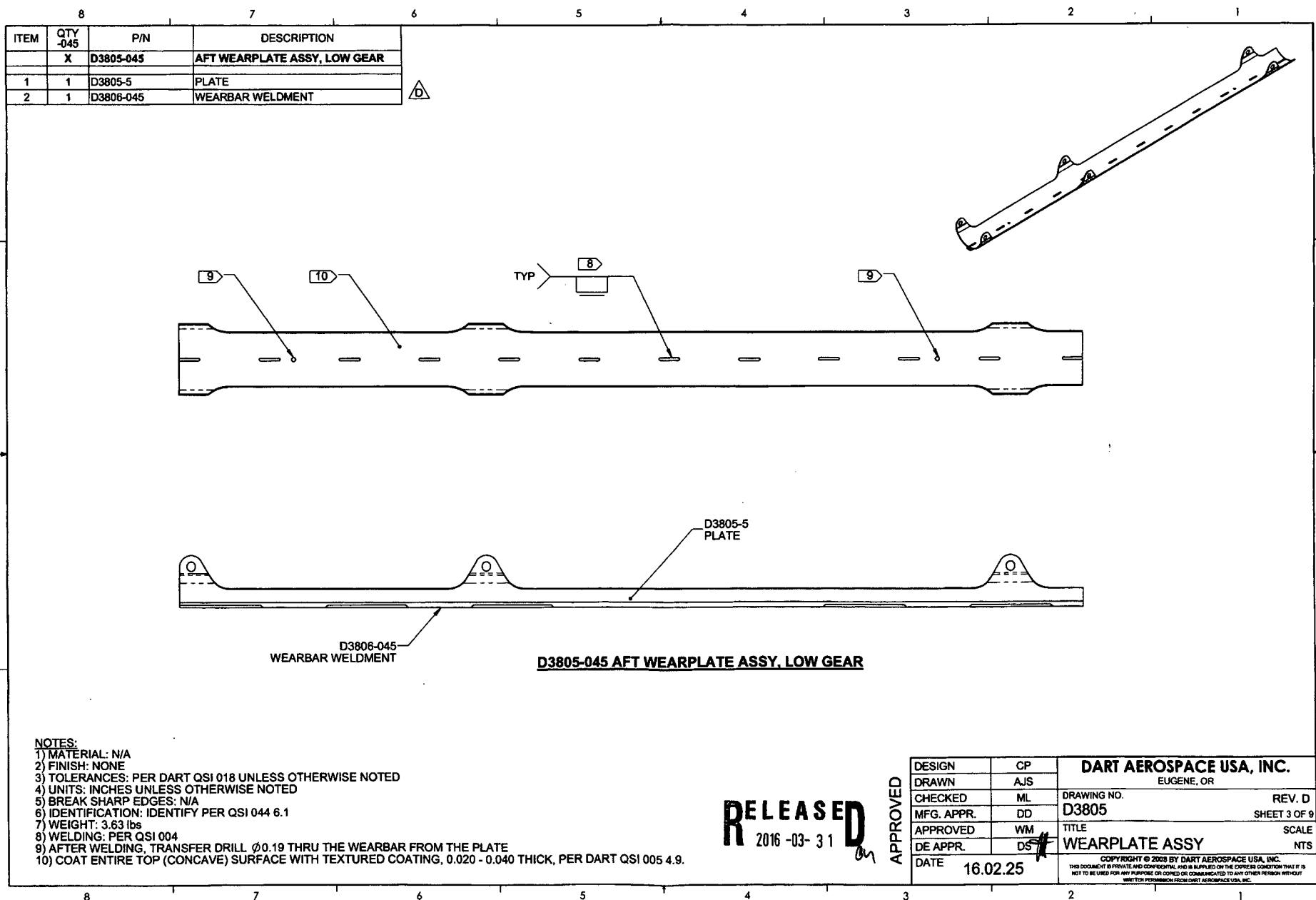
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.65 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\varnothing 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

RELEASED
2016-03-31

APPROVED

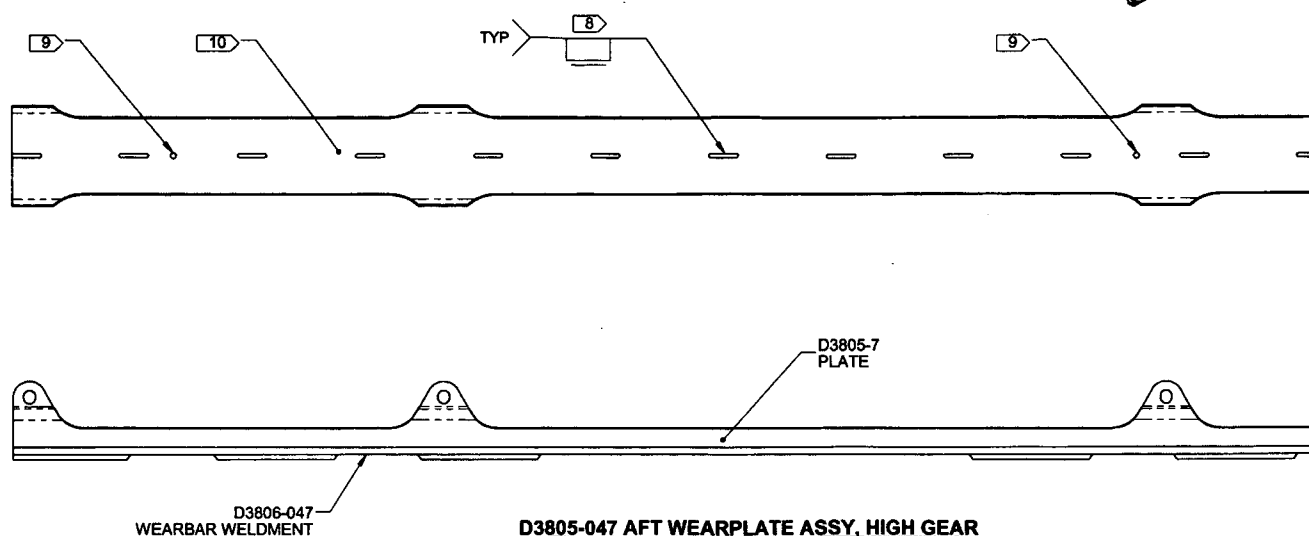
DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3805	SHEET 2 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.02.25	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



RELEASED
2016-03-31

APPROVED

ITEM	QTY -047	P/N	DESCRIPTION
	X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
1	1	D3805-7	PLATE
2	1	D3806-047	WEARBAR WELDMENT



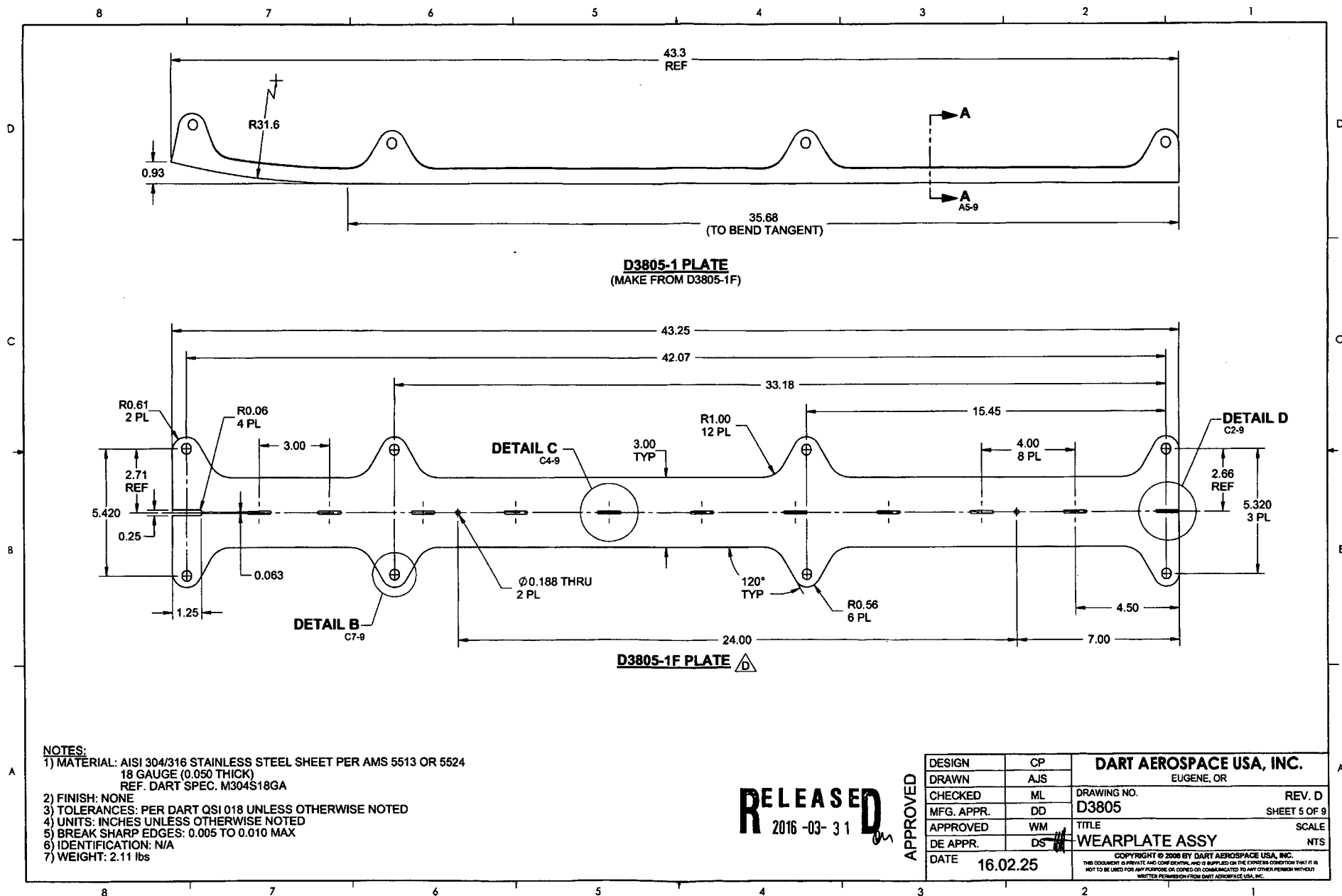
NOTES:

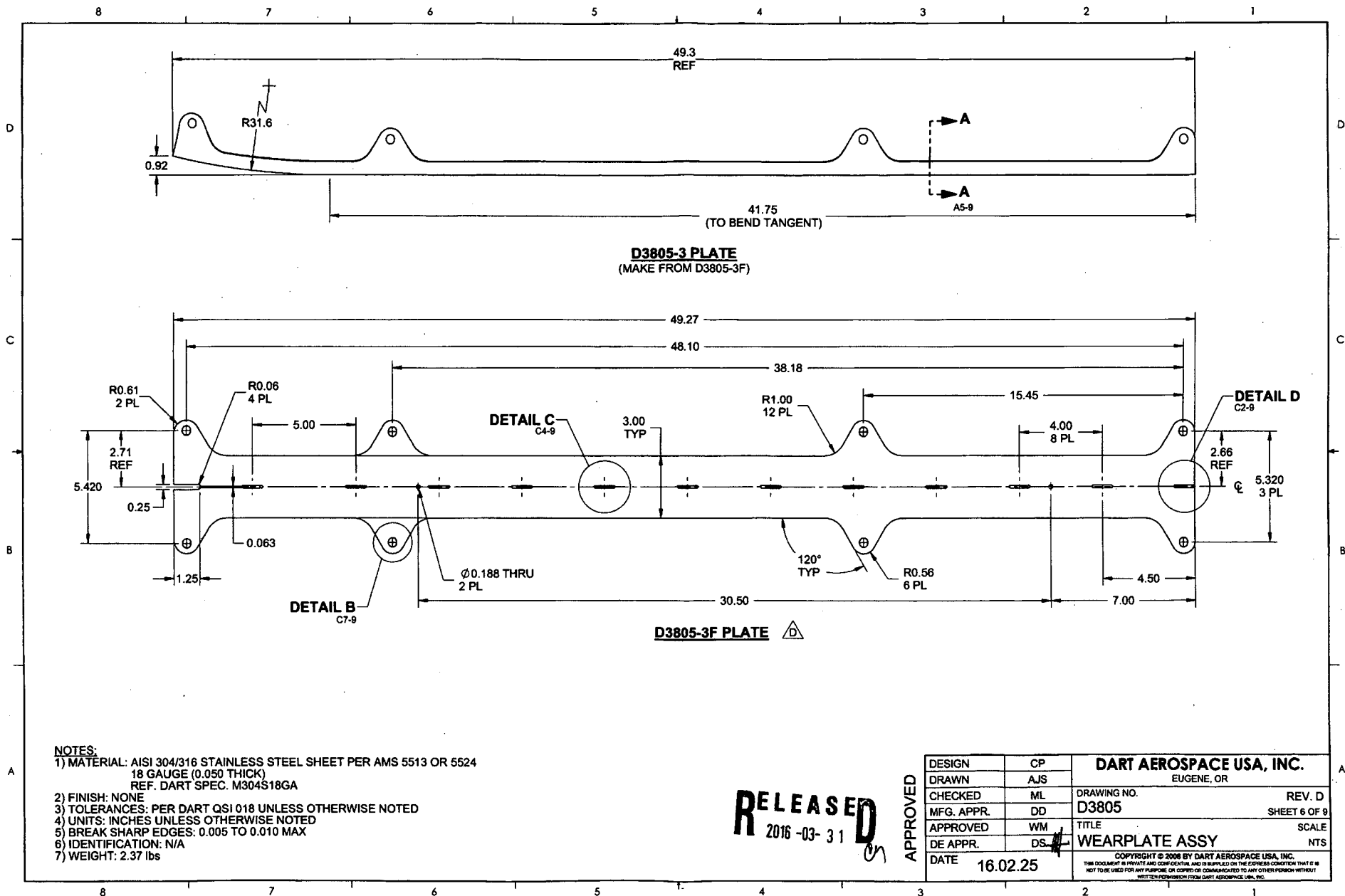
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.29 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\varnothing 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

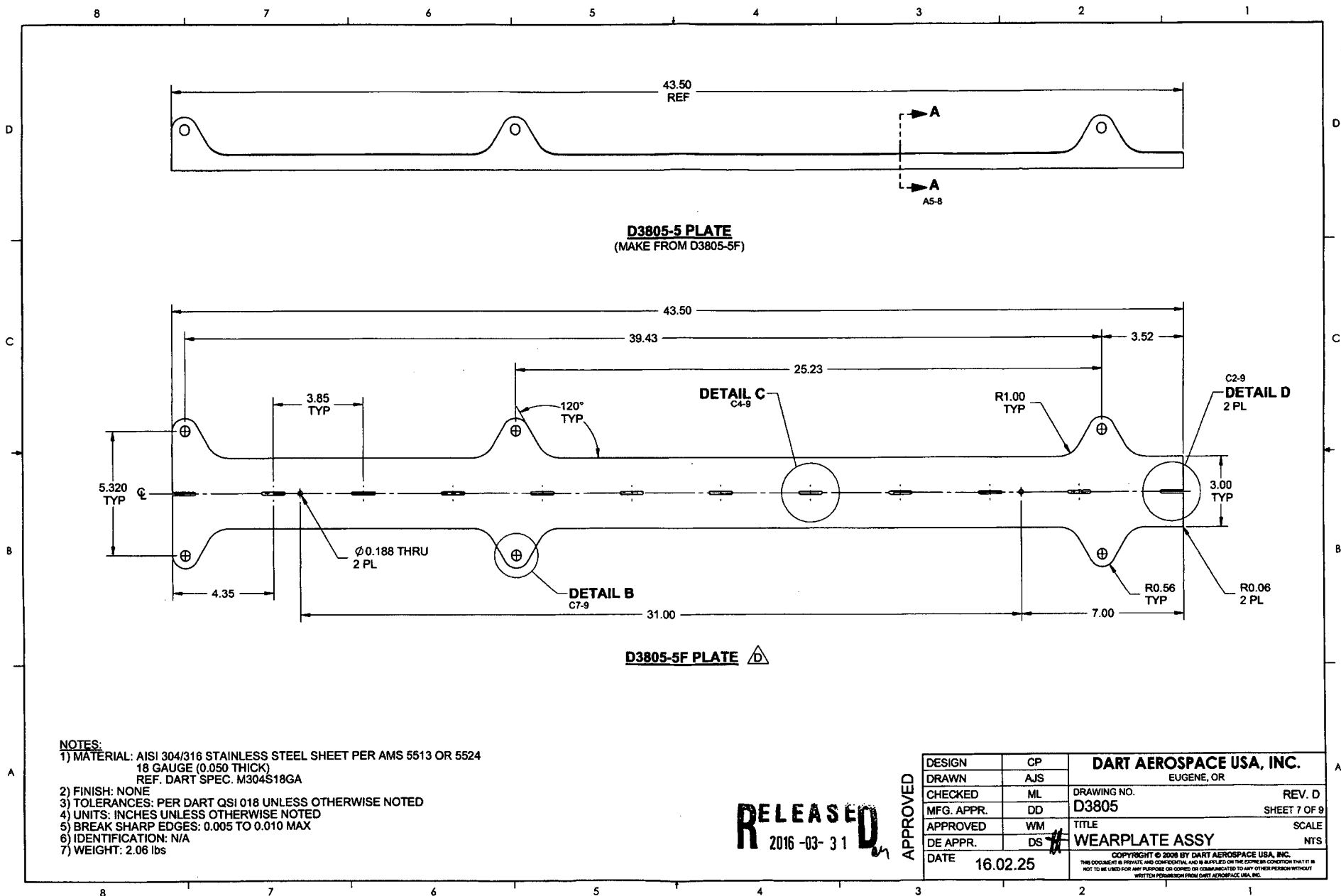
RELEASED
2016-03-31

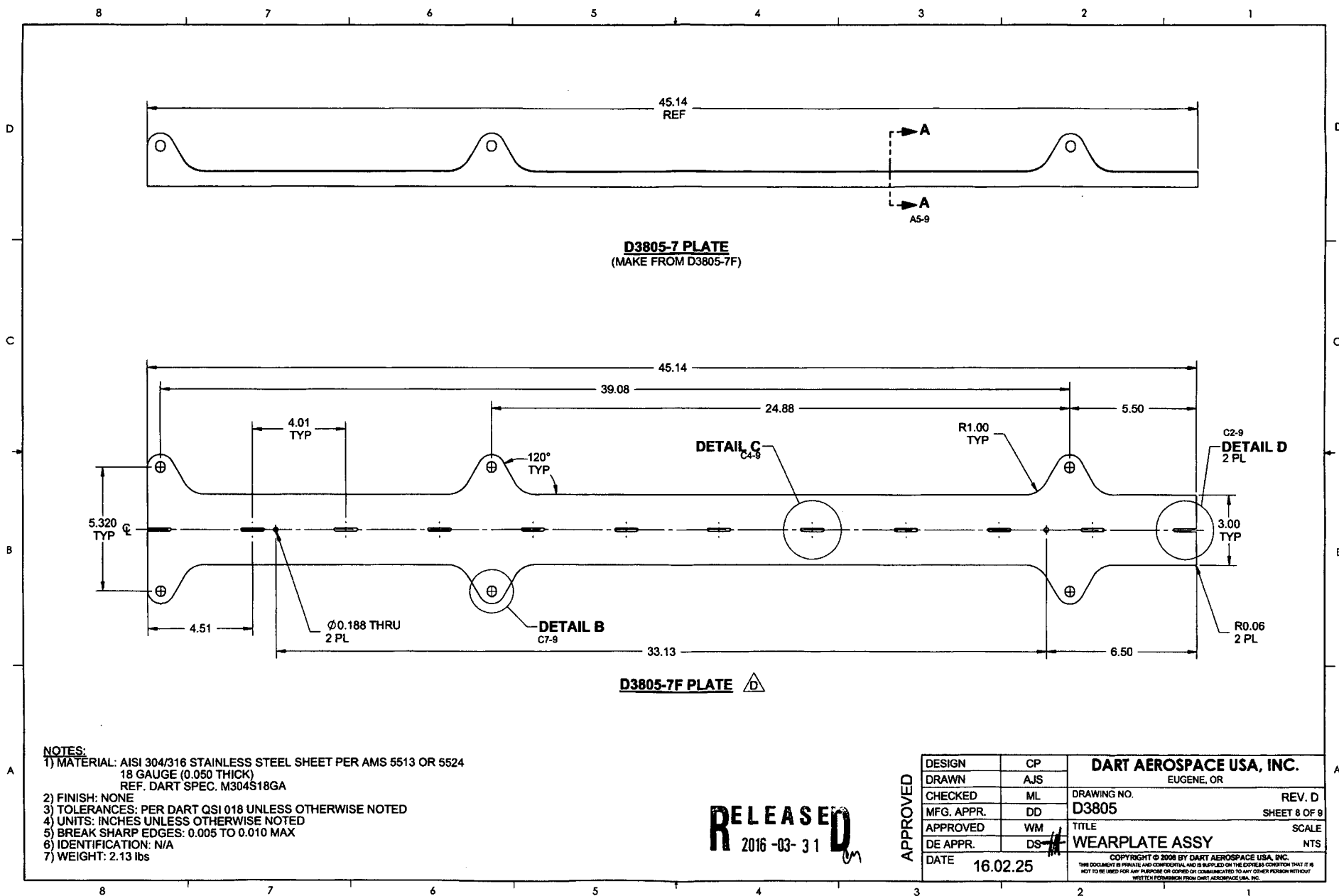
APPROVED

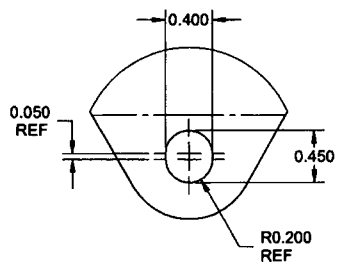
DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3805	SHEET 4 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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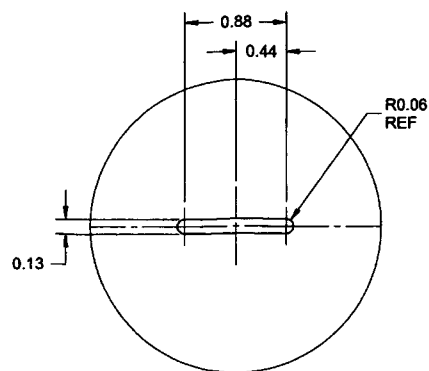




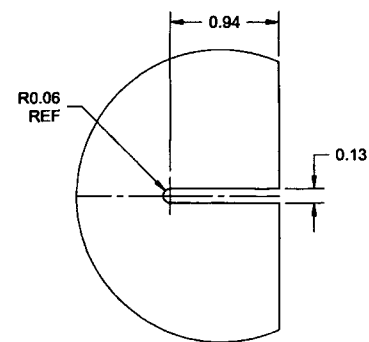




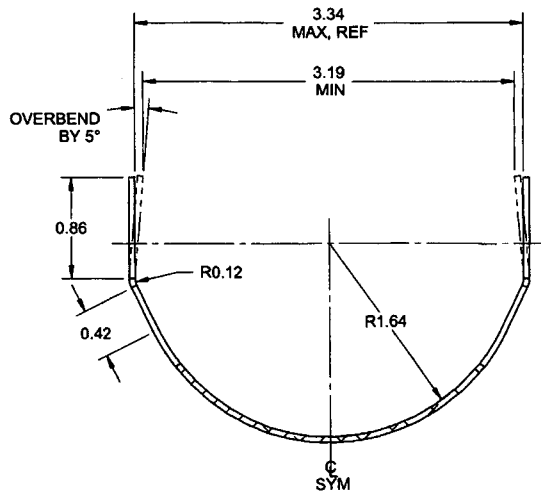
DETAIL B
SCALE 4X
B7-5
B7-6
B5-7
B5-8



DETAIL C
SLOT DETAIL TYP
SCALE 4X
C5-5
C5-6
C4-7
C4-8



DETAIL D
SLOT DETAIL TYP
SCALE 4X
C1-5
C1-6
C1-7
C1-8



SECTION A-A
SCALE 4X
D3-5
D3-6
D3-7
D3-8

RELEASED
2016-03-31

APPROVED

DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3805	SHEET 9 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						